



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBE350A93-3200-20-1
Job Sheet 194525



Part No: RBE350A93-3200-20-1

Job Qty: 12 pcs

Part Name: Main Gear Box/Rotor Brake Retaining Nut Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3200-20 REV:D IPP REV A 18.01.23 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	NLX 2500SY - 1	12 pcs	6/14/19	6/14/19	0.00	16.00	NLX 2500SY - 1	<i>P</i>
110	QC 2	12 pcs	6/14/19	6/14/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	<i>P</i>
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



Container No: S189200



Part: RBE350A93-3200-20-1

Job No: 194525

Serial No/Batch: S189200

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 06/11/19

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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130 QC 8	12 pcs	6/14/19	0.00	0.00	QC 2 - 5	
					QC 2 - 71	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B = 19-06-12
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
230 Packaging 3-1 - Stock - B4B	12 pcs	6/14/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	

5/3/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
240 QC 21 - SA	12 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - NLX (MORI NLX 2500SY LATHE) 1-Machine as per folio FB875 FOLIO REV: 4A DWG REV:

Descriptions: ① 2-Broach as per dwg. 3-Deburr

110 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

230 - (Identify as per dwg & Stock Location: _____)

240 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R2.000	17-4 SS H900 Round Bar 2.000"	1.5240 ft (.127 ea)	100-NLX 2500SY - 1	<u>S120117</u>
<u>1.667</u>				

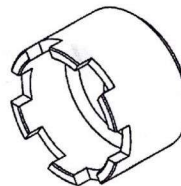
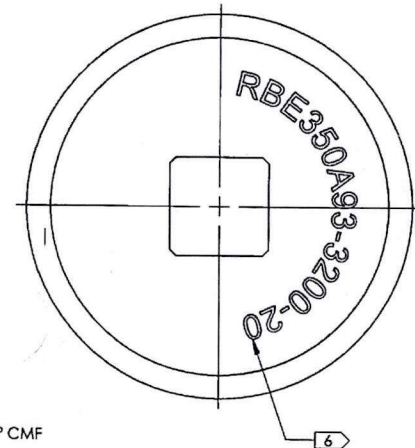
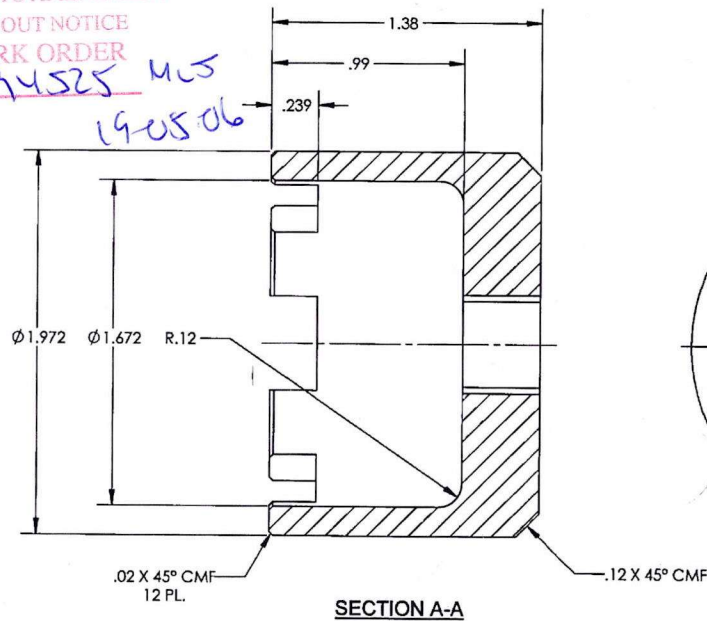
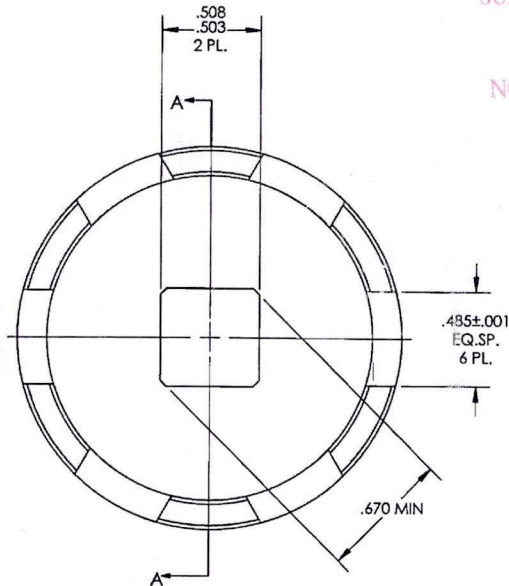
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-NLX 2500SY - 1	M17-4-H900-R2.000	2	16	0

Part Specifications
Specifications could not be found.

Plex 5/3/19 12:43 PM Dart.lajeunesse.marie

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
D	DIMENSION .505 CHANGED FOR .503/.508, TEMPLATE UPDATED, DIMENSION .985 CHANGED FOR .99, CHAMFER .02 X 45° 12 PL. ADDED, ENGRAVING CHANGED FOR MACHINE ENGRAVE, DIMENSION .670 MIN ADDED, DIMENSION .485 CHANGED FOR .485 +/- .001 EQ.SP. 6 PL., DIMENSION 60° (x8) REMOVED	17-799	17.12.21	VM	ML

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194525 ML
190506



NOTES:

- 1) MATERIAL: 17-4 PH-H900 SS
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN, 0.010" DEEP

RBE350A93-3200-20-1 MGB/ROTOR BRAKE RETAINING NUT WRENCH

DART AEROSPACE		Hawkebury, Ontario, Canada	
TITLE MGB/ROTOR BRAKE RETAINING NUT WRENCH			
PART NO. RBE350A93-3200-20		REV D	
TOOL NO. RBE350A93-3200-20		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY:	VM 17/12/21	TOLERANCES:	FRACTIONS ± 1/8
DRAWN BY:	VM 12/21/2017	XXX ± .006	ANGLES ± .5°
CHECKED BY:	VM 01/02/2018	XX ± .01	SURFACE
INFO REVIEW BY:	DD 01/02/2018	X ± .1	ROUGHNESS
APPROVED BY:	ML 01/04/2018	SCALE: NTS	SHEET 2 OF 6
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

